



FIG. 2

200

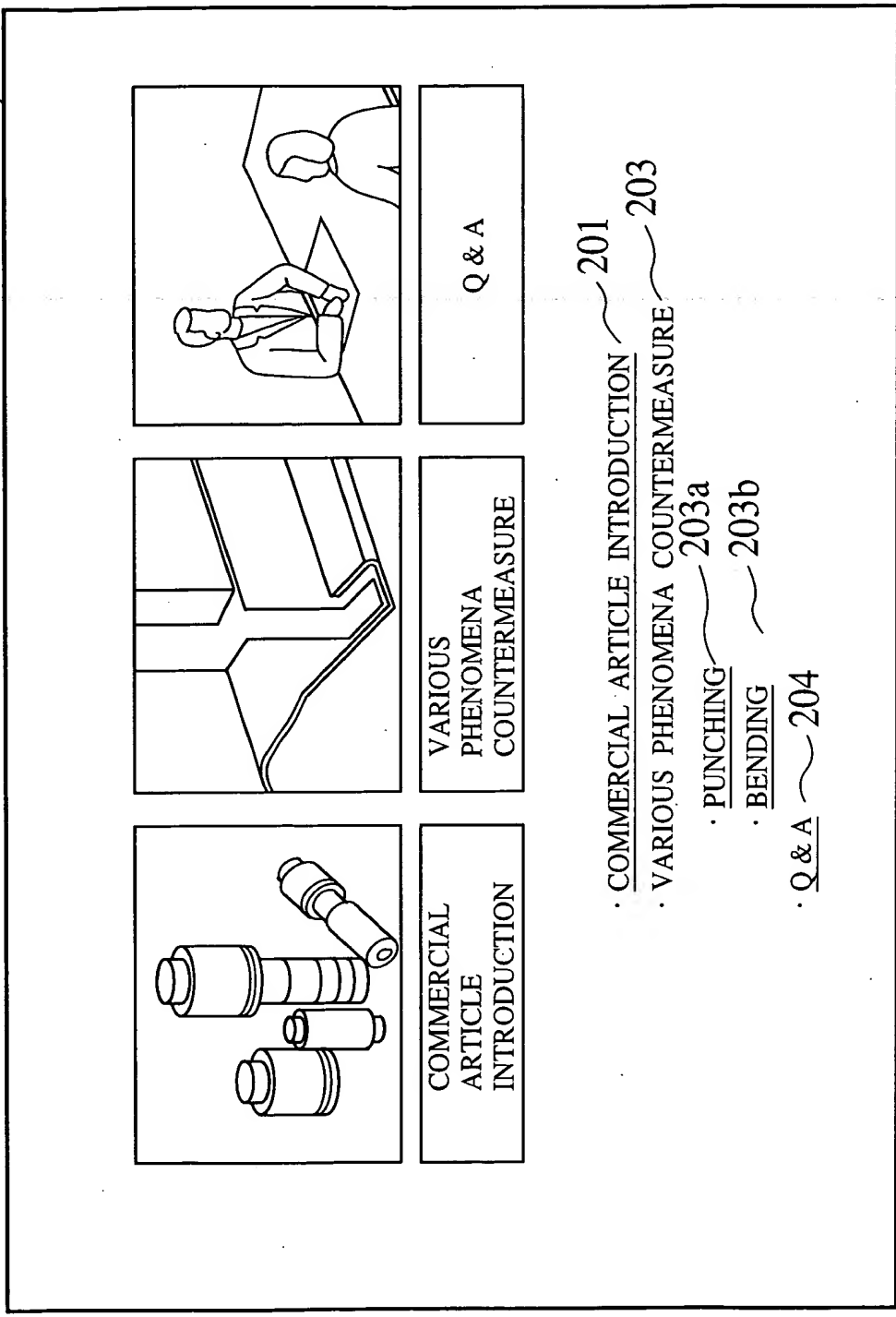
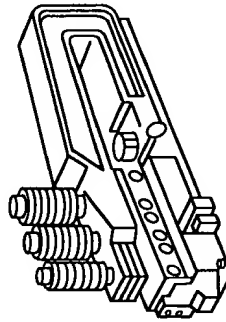


FIG. 3

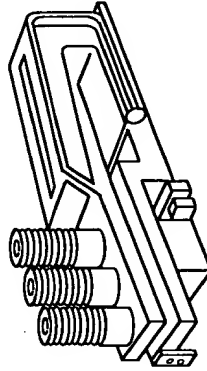
# TRIPLE HOLDER

- PUNCHING DIE HOLDER WITH TRIPLE ROLES
- LIGHT ONE-TOUCH MECHANISM FOR DIE SELECTION OWING TO EMPLOYMENT OF FREE BEARING
- EASY AND SECURE SHOT PIN SYSTEM FOR DIE POSITIONING

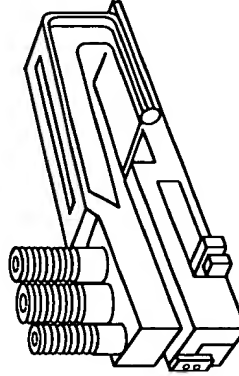
# FOR PUNCH SET (PS) DIES



FOR PR DIES



## FOR NTC LONG DIES



DIED TO BE USED	SA-64,SA-50,SA-38	1 1/4", 1 1/4", 1 1/4"(1 1/2")	
SLEEVE TO BE USED	SA-32, 38, 50 EACH SLEEVE (OPTION)	1/2" GUIDE SLEEVE (STANDARD)	(STANDARD)
HOLDER INTERIOR LENGTH	450(350)mm	450(350)mm	450mm
OPEN HEIGHT	230mm	244mm	313mm
SHUT HEIGHT	212mm	226mm	295mm
DIE HEIGHT	89mm	89mm	89mm

FIG.4

207

PROPOSAL FOR  
INCREASE PROFIT

TRIPLE HOLDER  
SEMI-AUTOMATIC  
TRIPLE HOLDER

HOME MENU

TRIPLE HOLDER INCREASE PROFIT 207a

(A) NUMBER OF HOLDER EXCHANGES PER ONE DAY? ~ 207b : 10 TIMES ~ 207e

(B) HOLDER EXCHANGE TIME PER ONE EXCHANGE? : 15 MIN. ~ 207f

(C) LABOR COST OF WORKING PERSON PER ONE HOUR? : 3000 YEN ~ 207g

(D) WORKING DAYS PER ONE MONTH? ~ 207d : 22 DAYS ~ 207h

CALCULATION

LABOR COST REQUIRED FOR HOLDER EXCHANGE

● SINGLE HOLER

LABOR COST PER ONE HOUR × EXCHANGE TIME PER ONE × NUMBER OF EXCHANGES  
PER ONE DAY × WOKING DAYS PER ONE MONTH  
= 165,000 YEN

● TRIPLE HOLDER 207i

HOLDER EXCHANGE TIMES BECOMES 1/3 SINCE BECAUSE THREE DIES CAN BE  
MOUNTED ON TRIPLE HOLDER

LABOR COST PER ONE HOUR × EXCHANGE TIME PER ONE TIME × NUMBER OF 207j  
EXCHANGES PER ONE DAY × 1/3 × WORKING DAYS PER ONE MONTH  
= 55,000 YEN

INCREASE PROFIT PER ONE MONTH = LABOR COST OF CONVENTIONAL SINGLE  
HOLDER - LABOR COST OF INTRODUCED TRIPLE HOLDER = 110,000 YEN

RETURN 207k

FIG.5

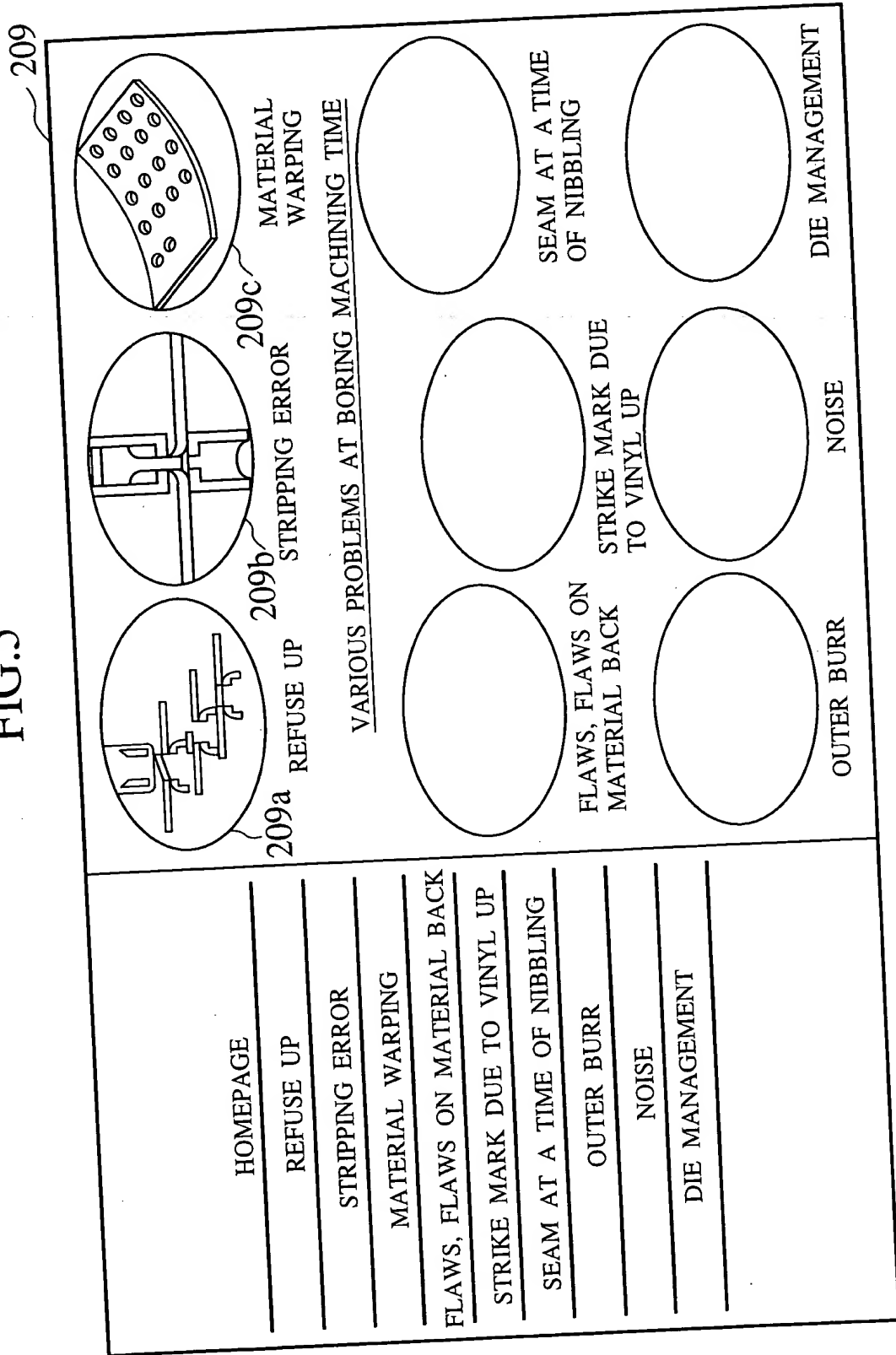


FIG.6

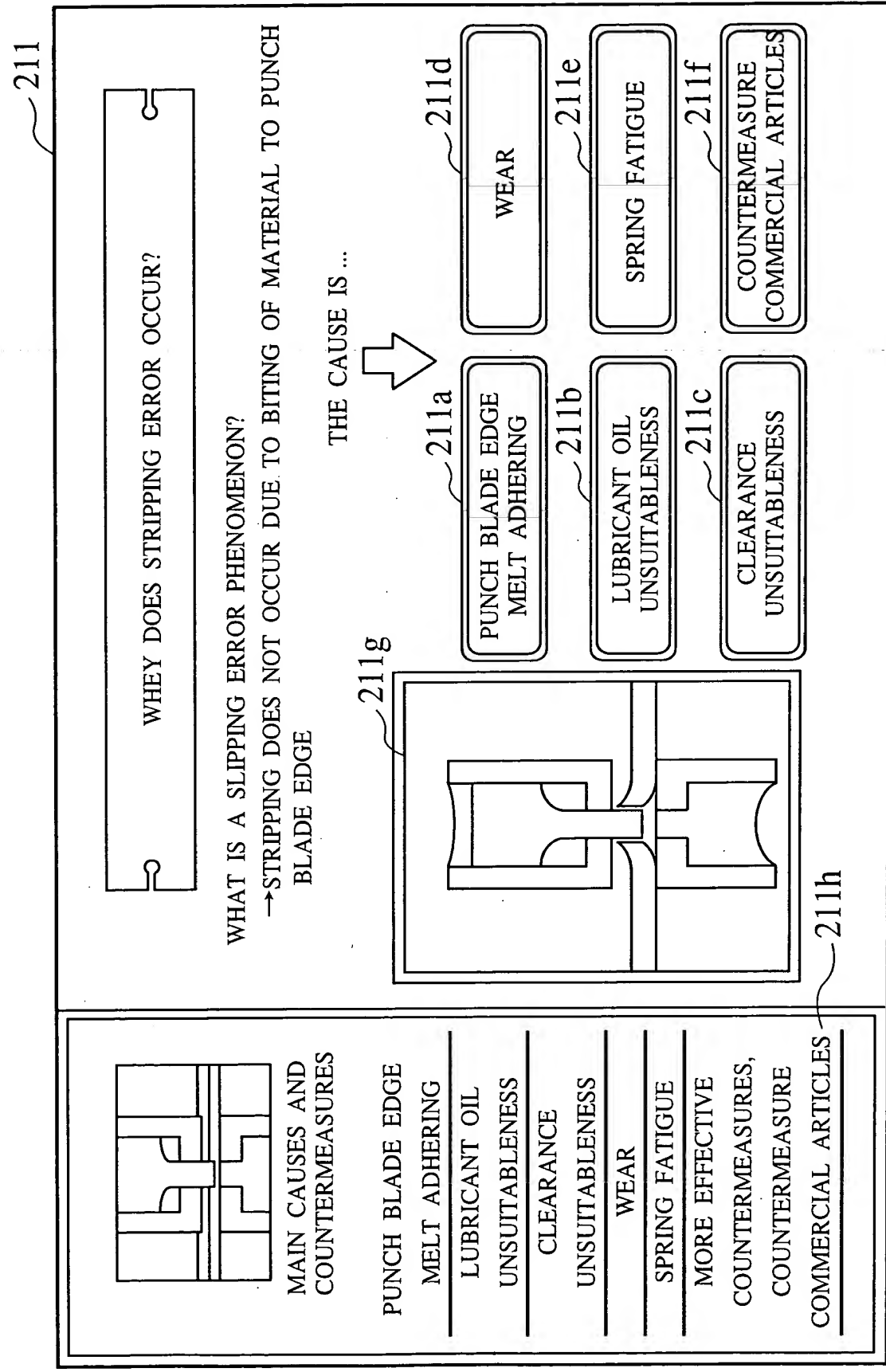
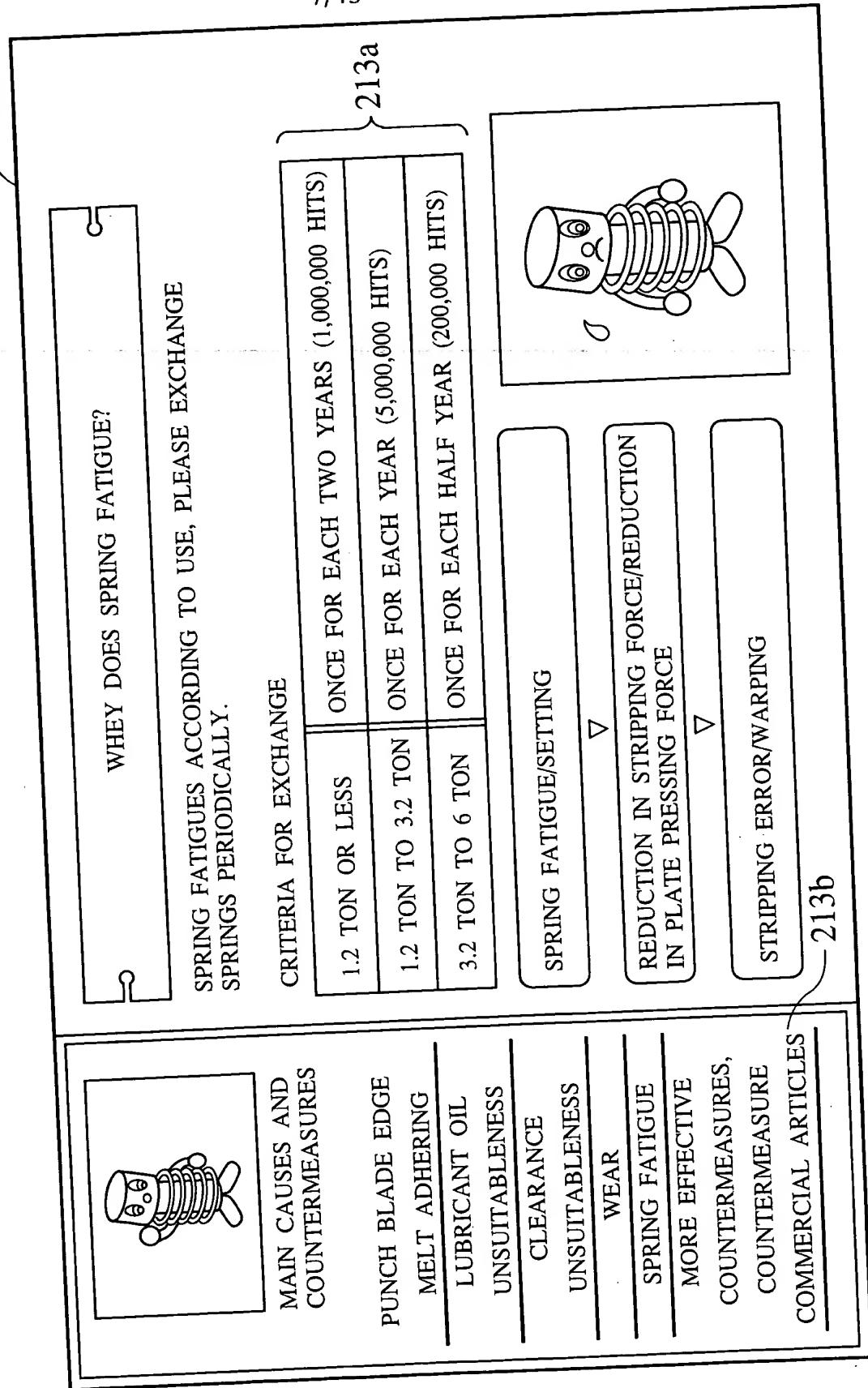


FIG. 7



8/43

FIG.8

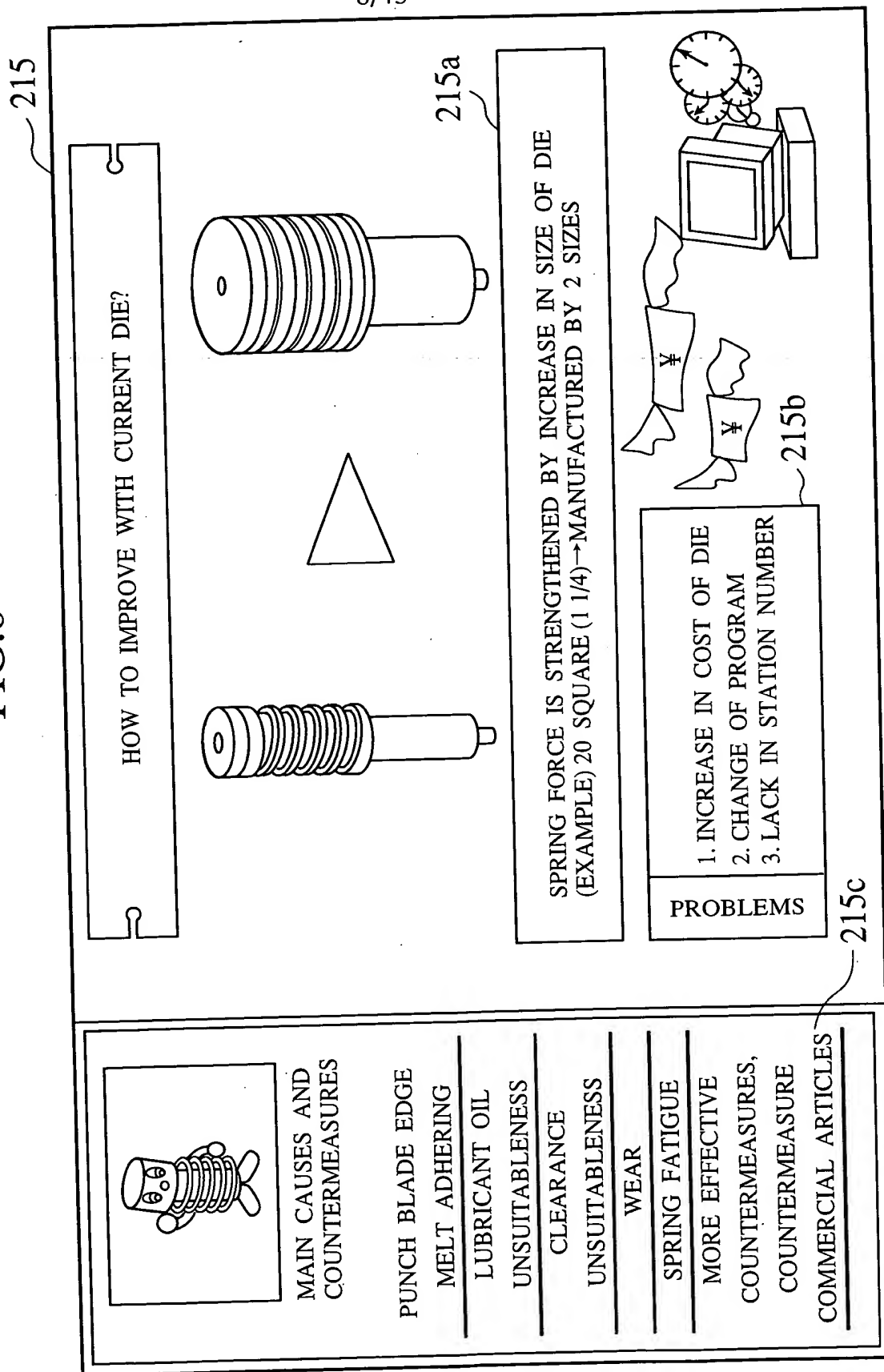






FIG.10

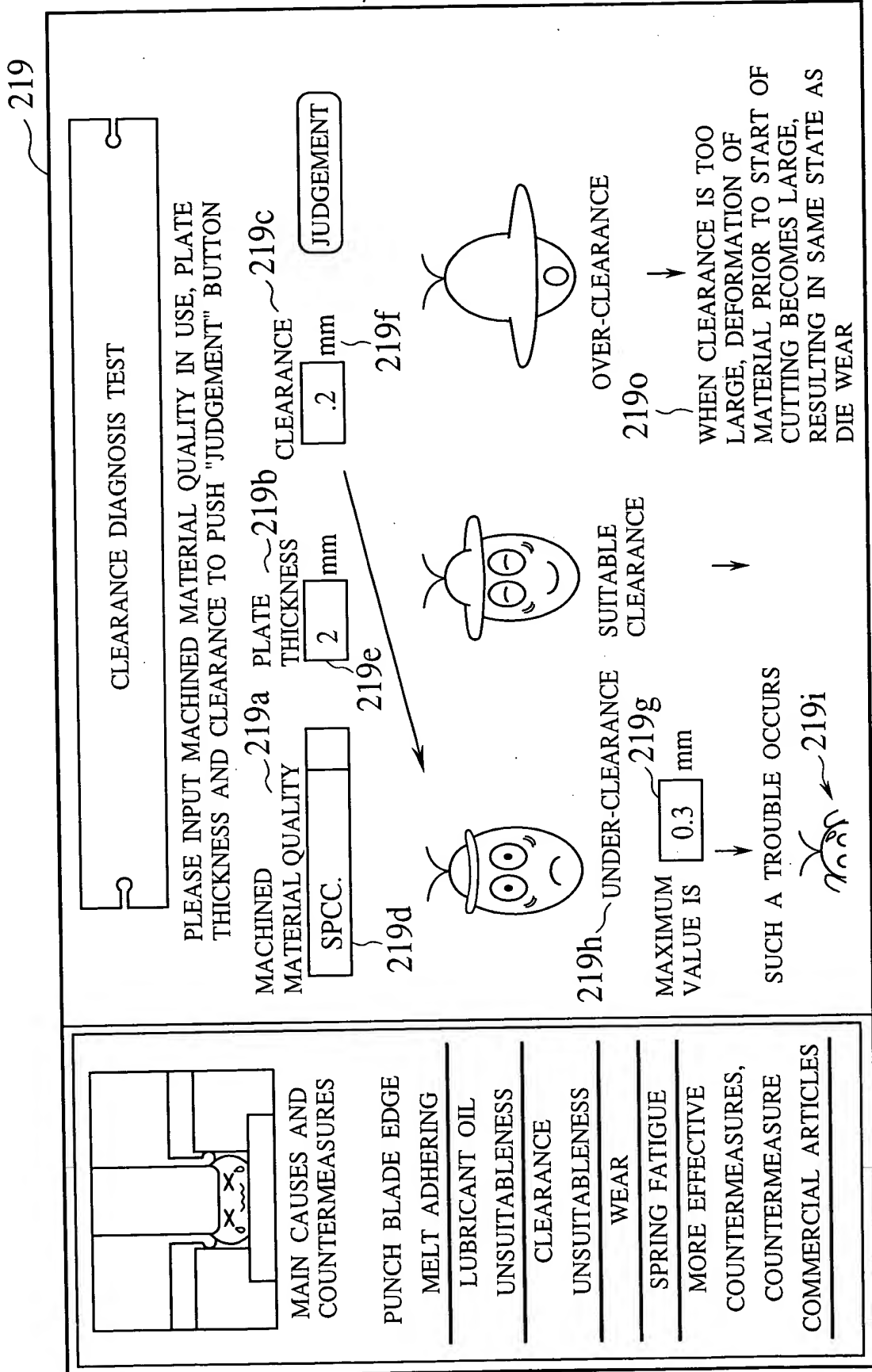


FIG. 11

221

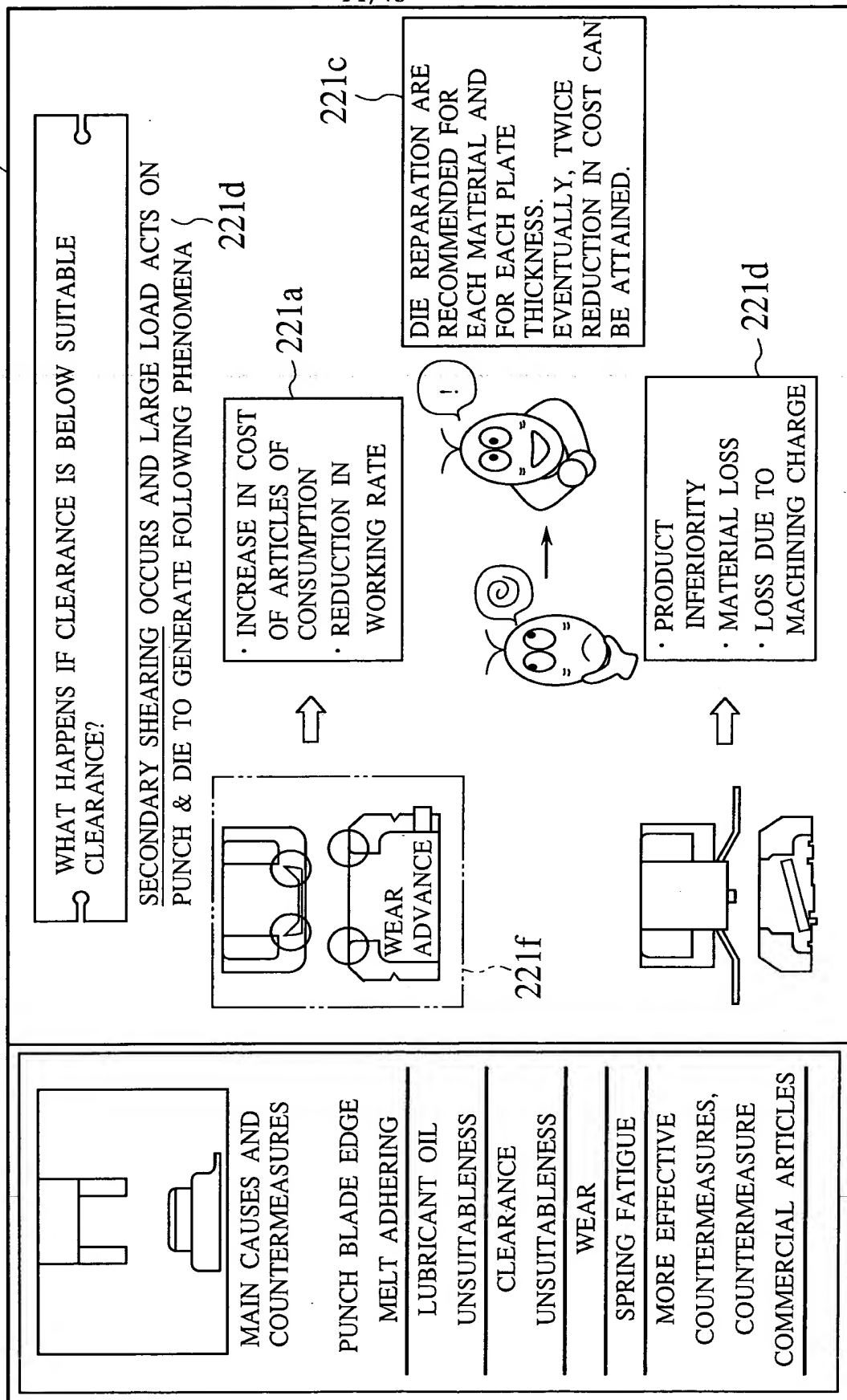
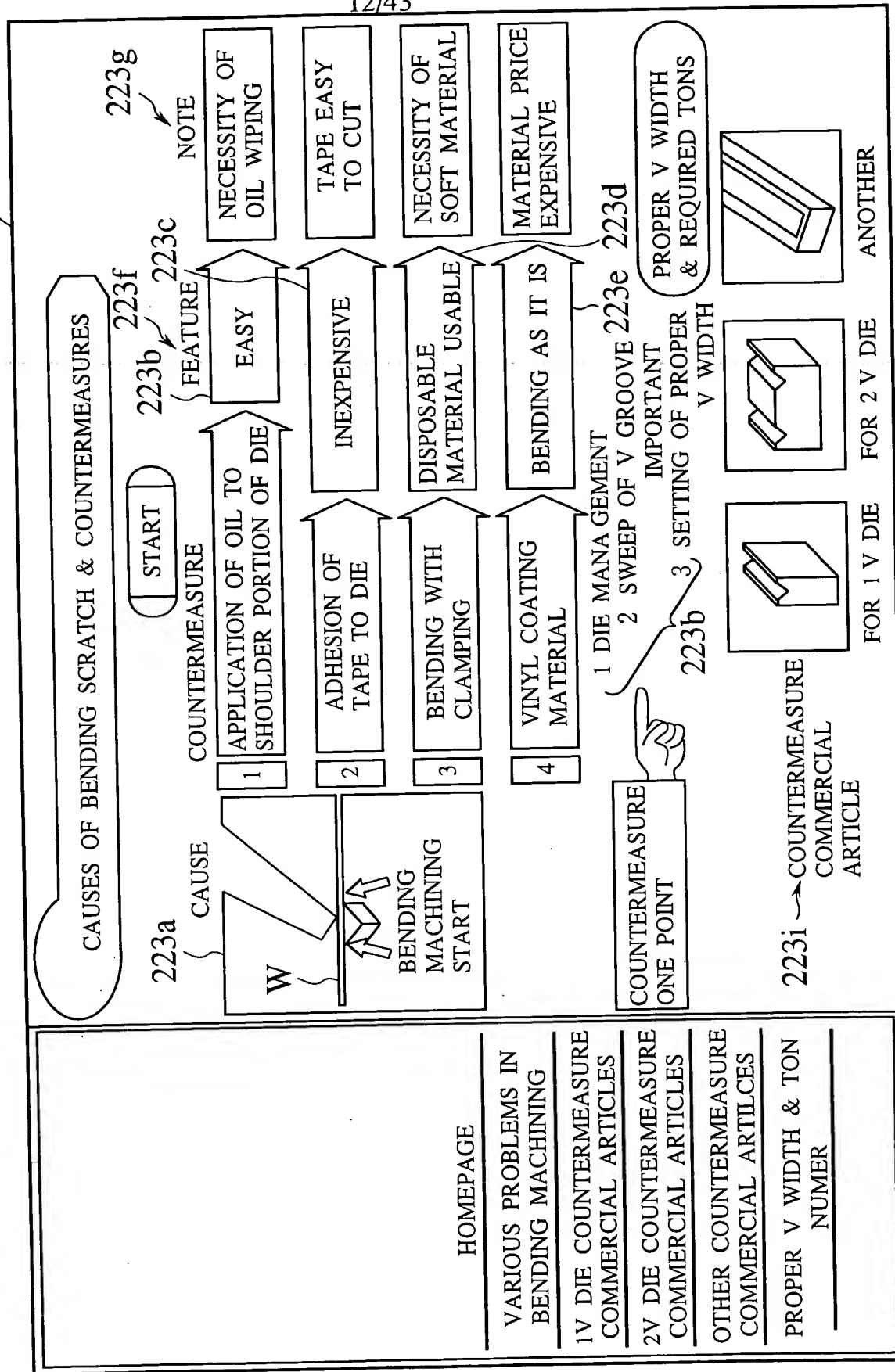


FIG.12

223



HOMEPAGE

- VARIOUS PROBLEMS IN BENDING MACHINING
- 1V DIE COUNTERMEASURE COMMERCIAL ARTICLES
- 2V DIE COUNTERMEASURE COMMERCIAL ARTICLES
- OTHER COUNTERMEASURE COMMERCIAL ARTICLES
- PROPER V WIDTH & TON NUMBER

225

FIG.13

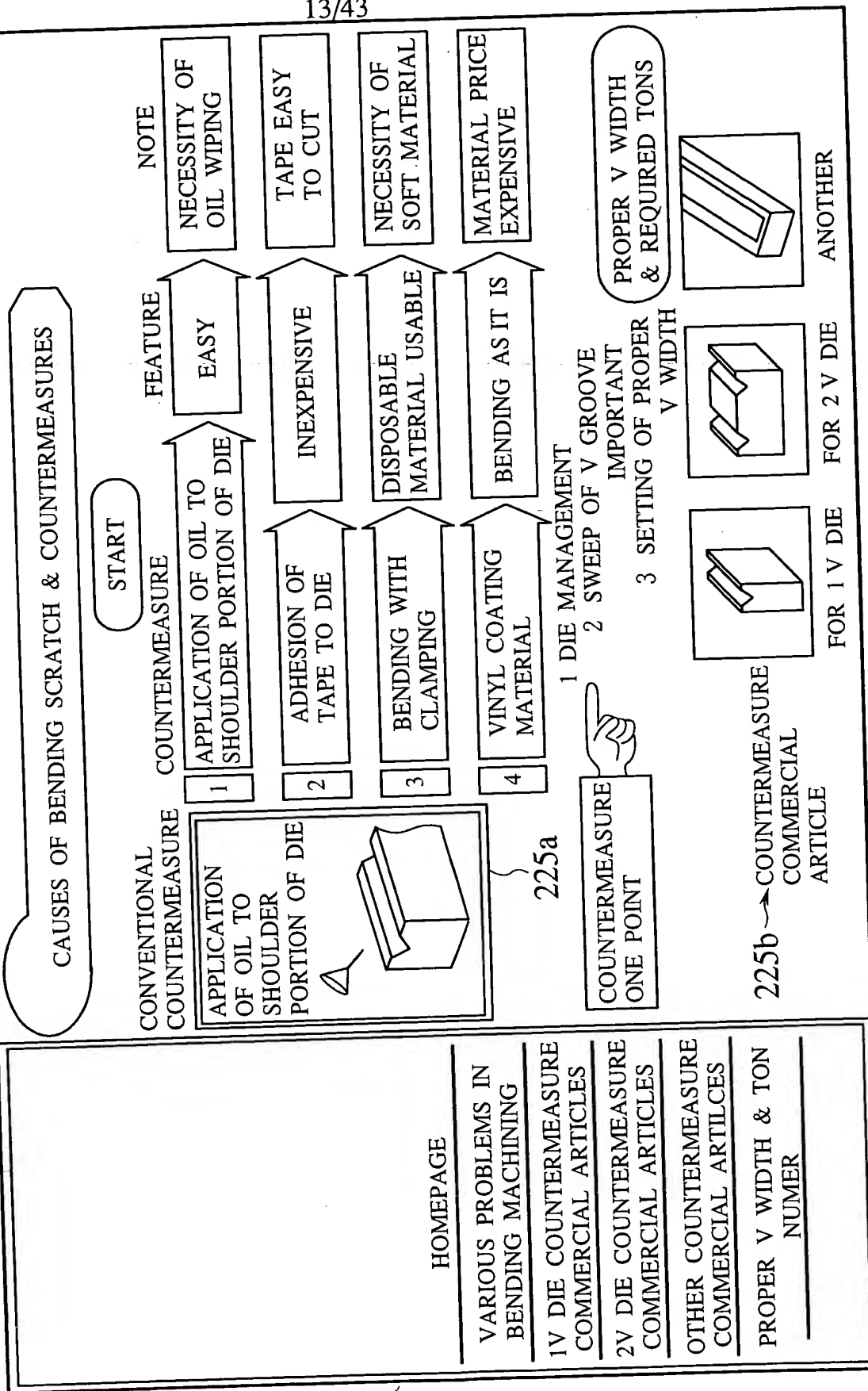


FIG.14

225

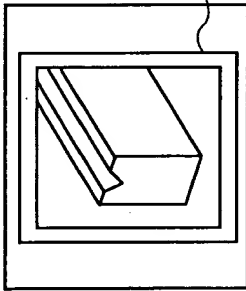
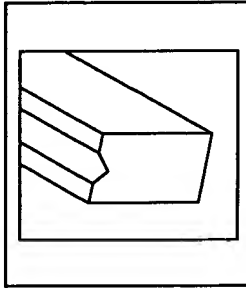
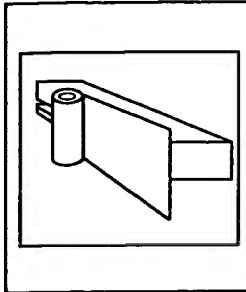
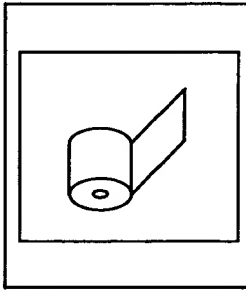
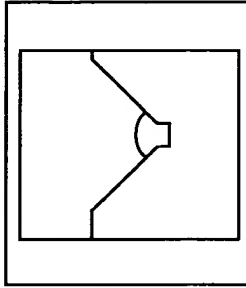
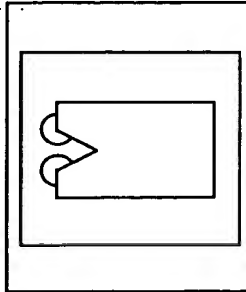
<div>1V DIE COUNTERMEASURE COMMERCIAL ARTICLE</div> <div>227b 227a</div>		
COMMERCIAL ARTICLE NAME : SELATIC DIE		
FEATURE : LIGHT & INEXPENSIVE		
PROPER MATERIAL QUALITY : STAINLESS STEEL, IRON, BONDERIZING THIN PLATE		
ACCORDING TO SELECTION OF PICTURE, EXPLANATION IS DISPLAYED ON BLUE FRAME		
		
SELATIC DIE	HARD PLATING	URETHANE SHEET
		
SELATIC DIE	HARD PLATING	URETHANE SHEET

FIG. 15

229

15/43

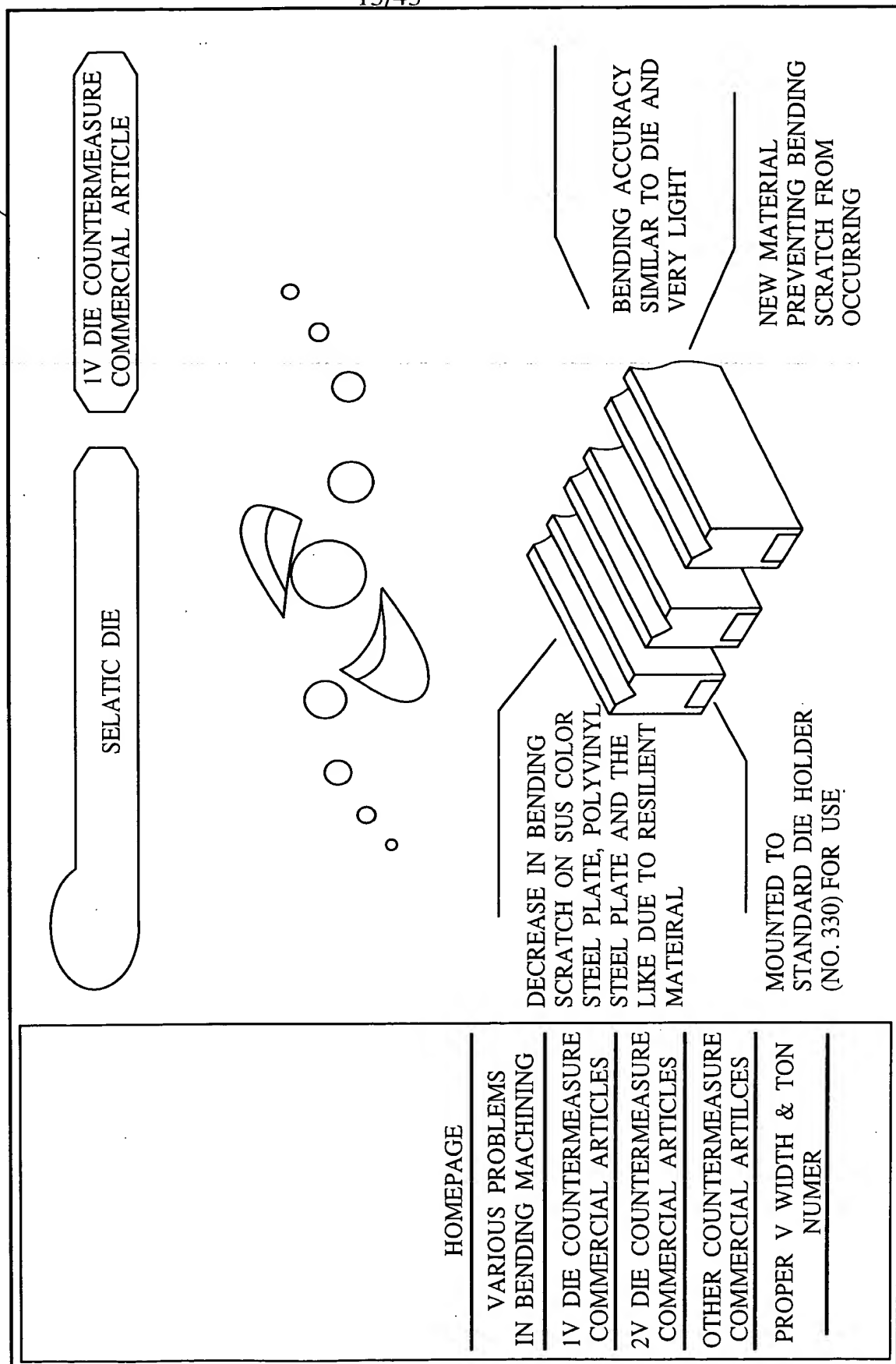

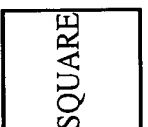
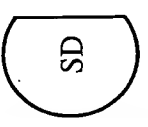



FIG.16

231a

PUNCHING	BENDING	SET
231b <input type="checkbox"/> TRIMMING {P1} <input checked="" type="checkbox"/> STANDARD {Q1} <input type="checkbox"/> SPECIAL SHAPE {Q1}		
<input type="checkbox"/> FORMING {P2} <ul style="list-style-type: none"> <li>- BURRING {Q3}</li> <li>- EMBOSSING {Q4}</li> <li>- COUNTERSINK {Q5}</li> <li>- DOWELING {Q6}</li> <li>- LOUVRE {Q7}</li> <li>- COUNTERSINK {Q8}</li> <li>- MARKING {Q9}</li> <li>- HALF SHEAR {QA}</li> <li>- KNOCK OUT {QB}</li> </ul>		
SHAPE FIGURE <div style="display: flex; justify-content: space-around;"> <div>  <p>ROUND</p> </div> <div>  <p>SQUARE</p> </div> <div>  <p>SD</p> </div> <div>  <p>CENTER PUNCH</p> </div> </div>		
ADAPTIVE FIGURE		
231d ~ <div style="display: flex; justify-content: flex-end;"> <div>SELECTION</div> <div>CLOSE</div> </div>		

231c

231



FIG.17

233

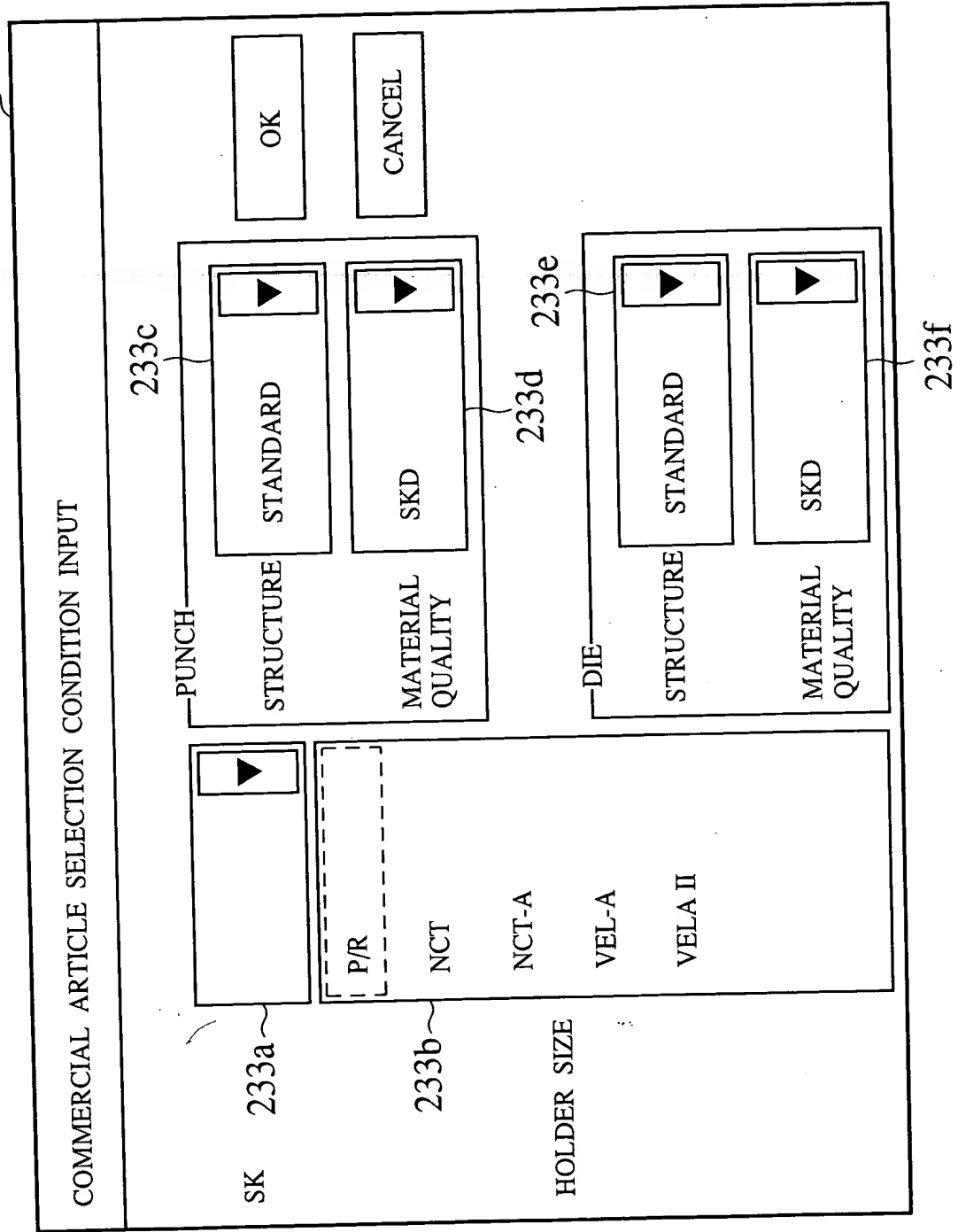


FIG.18

233

COMMERCIAL ARTICLE SELECTION CONDITION INPUT

SK 233a

NCT

233b

HOLDER SIZE

1 1/4"

PUNCH

STRUCTURE

STANDARD

MATERIAL QUALITY

SKD

DIE

STRUCTURE

STANDARD

MATERIAL QUALITY

SKD

OK

CANCEL

00000005200000

FIG.19

COMMERCIAL ARTICLE SELECTION CONDITION INPUT

SK

NCT

HOLDER SIZE

11/4

PUNCH

STRUCTURE

STANDARD

MATERIAL QUALITY

SKD

DIE

STRUCTURE

STANDARD

MATERIAL QUALITY

SKD

OK

CANCEL

FIG.20

235

PARTS LIST

1/1

11/4 AIR BLOW

12.71~30.0 φ

235a

235b

SPEC. DETAILED FIGURE			
No.	COMMERCIAL ARTICLE NAME	UNIT PRICE	QUANTITY
01	SET ASSY	XX,XXX	
02	PUNCH ASSY	XX,XXX	
03	PUNCH BODY	XX,XXX	
04	DIE	X,XXX	
05	PUNCH GUIDE	XX,XXX	
06	PUNCH HEAD	X,XXX	

SIZE INPUT

A SIZE

B SIZE

CLEARANCE

DEDICATED KEY

CORNER R

SPECIAL MENTION

SELECTION

CLOSE

FIG.21

COMMERCIAL ARTICLE SELECTION

PUNCHING BENDING SET

NON-PATTERN

237

237a

237b

TRIMMING <P1> 237b

STANDARD <Q1> {

SPECIAL SHAPE <Q2> {

FORMING <P2>

BURRING <Q3>

EMBOSSING <Q4>

COUNTERSINK <Q5>

DOWELING <Q6>

LOUVRE <Q7>

COUNTERSINK <Q8>

MARKING <Q9>

HALF SHEAR <QA>

KNOCK OUT <QB>

SHAPE FIGURE

I II III IV V VI VII VIII

237c

ADAPTIVE FIGURE

237d

SELECTION

CLOSE

FIG.22

**COMMERCIAL ARTICLE SELECTION**

**PUNCHING**

TRIMMING <P1>

STANDARD <Q1>

SPECIAL SHAPE <Q2>

**BENDING**

FORMING <P2>

BURRING <Q3>

EMBOSSING <Q4>

COUNTERSINK <Q5>

DOWELING <Q6>

LOUVRE <Q7>

COUNTERSINK <Q8>

MARKING <Q9>

HALF SHEAR <QA>

KNOCK OUT <QB>

**NON-PATTERN**

**SHAPE FIGURE**

I	II	III	IV	V	VI	VII	VIII

**ADAPTIVE FIGURE**

239a

239b

239c

FIG. 23

FIG. 23

MACHINING POSSIBILITY

SIZE INPUT PATTERN 1/8

241b

241a

ITEM

VALUE

A

10

B

0

K

0

R

0

S

0

KY

270

SIZE

241c

SK

NCT

241e

HOLDER SIZE

1/2"

241f

PUNCH

STRUCTURE

STANDARD

241g

MATERIAL

QUALITY

SKD

241h

DIE

STRUCTURE

STANDARD

241i

MATERIAL

QUALITY

SKD

241j

TOTAL SHOTS

241k

MACHINING POSSIBILITY

CANCEL

241l

FIGURE POSITION

241m

PRINT

241n

FIGURE SIZE

241o

ENLARGEMENT

241p

REDUCTION

241q

LEFT

241r

CENTER

241s

RIGHT

241t

DOWN

23/43

241

A

X-AXIS

R

K

B

S

FIG. 24

243b

MACHINING POSSIBILITY

243a

SIZE INPUT PATTERN

3/8

<

>

P102-02

ITEM

VALUE

B

0

C

0

L

0

R

0

S

0

KY

270

SIZE

243c

SK

NCT

243e

HOLDER SIZE

1/2"

243f

PUNCH

STRUCTURE

STANDARD

243g

MATERIAL

SKD

243h

QUALITY

DIE

STRUCTURE

STANDARD

243i

MATERIAL

SKD

243j

QUALITY

TOTAL SHOTS

CLEARANCE

243d

MACHINED MATERIAL

PLATE THICKNESS

MATERIAL QUALITY

SPCC

243k

MACHINING POSSIBILITY

CANCEL

FIGURE SIZE

ENLARGEMENT

REDUCTION

FIGURE POSITION

UP

CENTER

RIGHT

LEFT

DOWN

FIGURE PRINT

PRINT

X-AXIS

B

C

2-L

2-S

R



FIG. 25

245a

MACHINING POSSIBILITY

SIZE INPUT PATTERN 3/8 <> P102-02

245

245d

245f

245b

245g

245c

X-AXIS

180°

R

B

C

2-L

2-S

ITEM	VALUE
B	15
C	15
L	75
R	1
S	1
KY	180

SIZE

SK NCT

HOLDER SIZE 2"

PUNCH STRUCTURE STANDARD

MATERIAL QUALITY SKD

DIE STRUCTURE STANDARD

MATERIAL QUALITY SKD

TOTAL SHOTS 1

CLEARANCE 0.15

PLATE THICKNESS 1

MATERIAL QUALITY SPCC

MACHINING POSSIBILITY [SELECTION] [CANCEL]

FIGURE SIZE

ENLARGEMENT

REDUCTION

FIGURE POSITION

UP

CENTER

DOWN

LEFT

RIGHT

FIGURE PRINT

PRINT

\*CAPABLE OF MACHINING

26/43

FIG.26

247

247b

247c

247a

1/1

2"

SPECIAL  
SHAPE

③

⑤

④

INSCRIBED  
IN 50.8 φ

SPEC.

DETAILED FIGURE

No.	COMMERCIAL ARTICLE NAME	UNIT PRICE	QUANTITY
01	SET ASSY	XX,XXX	
02	PUNCH ASSY	XX,XXX	
03	PUNCH BODY	XX,XXX	
04	DIE	XX,XXX	
05	STRIPPER PLATE	X,XXX	

SPECIAL  
MENTION

SELECTION

CLOSE

FIG.27

249

249a

COMMERCIAL ARTICLE SELECTION		
PUNCHING	BENDING	SET
<input type="checkbox"/> ONE TOUCH <B1> <input type="checkbox"/> SK=11- <C0> <input checked="" type="checkbox"/> PUNCH HOLDER <C1> <input type="checkbox"/> PUNCH <C2> <input type="checkbox"/> STANDARD PUNCH <D8> <input type="checkbox"/> THICK MATERIAL PUNCH <D9> <input type="checkbox"/> GOOSE NECK (H90) ~ 249b <input type="checkbox"/> GOOSE NECK G SERIES <input type="checkbox"/> FRONT RECESS, FR <DC> <input type="checkbox"/> FOR SASH (H70~100 <input type="checkbox"/> POINT PUNCH (H95 < <input type="checkbox"/> ACUTE-ANGLED PUNCH(H67~ <input type="checkbox"/> FLATENING PUNCH <input type="checkbox"/> ALP PUNCH <DH> <input type="checkbox"/> R PUNCH <D1> <input type="checkbox"/> HINGE PUNCH <D> <input type="checkbox"/> MIDDLE HAND PUNCH (H8 <input type="checkbox"/> CLOSING PUNCH <input checked="" type="checkbox"/> DIE <C3> <input type="checkbox"/> STEP BENDING/L-SHAPE BENDING <CJ> <input type="checkbox"/> STANDARD <B2> <input type="checkbox"/> SK=10- <C7> <input checked="" type="checkbox"/> PUNCH HOLDER <C8> <input checked="" type="checkbox"/> PUNCH <C9> <input checked="" type="checkbox"/> DIE <CA> <input checked="" type="checkbox"/> MEASURING INSTRUMENT <CG> <input type="checkbox"/> TOOL BOX <CH> <input type="checkbox"/> STEP BENDING/L-SHAPE BENDING <C1> SELECTION FROM WORKPIECE <B3>		
SHAPE FIGURE 249d 		
ADAPTIVE FIGURE ~ 249e <div style="display: flex; justify-content: space-between;"> <div>SELECTION</div> <div>CLOSE</div> </div>		

NON-PATTERN

249c

SHAPE FIGURE 249d

ADAPTIVE FIGURE ~ 249e

SELECTION

CLOSE

251

FIG. 28

251a

PARTS LIST

1/1

NO. 453 TYPE (H90)

No	COMMERCIAL ARTICLE NAME	UNIT PRICE	QUANTITY
1	01 GOOSE PUNCH #453(L)	xxx,xxx	1
	01 GOOSE PUNCH #453(S)	xx,xxx	
	01 GOOSE PUNCH #453(DIVISION)	xxx,xxx	

251b

251d

251c

O NO TIP END R

TIP END R

.2

SPECIAL  
MENTION

SELECTION

CLOSE

120

90

6

88 DEGREE

DIVISION  
EAR SHAPE

30

10R

10

25

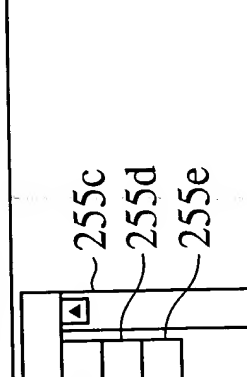
TIP END R : 0.2, 0.6, 0.8, 1.5, 3.0

FIG. 29

Figure 1 is a schematic diagram of a computer screen displaying a "SPECIAL MENTION ITEM SELECTION" window. The window is divided into several sections. At the top, a "COMMERCIAL ARTICLE" field contains the text "11-453021". To its right is a field containing the text "ONE TOUCH 88' GOOSE NECK 0.2R L". Below these fields is a list of "APPLICABLE SPECIAL MENTION ITEM" options, including "001 CUSTOMER SPECIFIED MARK", "002 CHECK TABLE ATTACHED", "023 CUT SIZE WITHOUT EAR", "024 MATCHING OF CUSTOMER DIE HEIGHT", "032 DESIGNATION OF RIGHT EAR LENGTH", and "033 DESIGNATION OF LEFT EAR LENGTH". To the right of this list is a large "APPLIED SPECIAL MENTION ITEM" area. At the bottom of the window, there is a section for "ADDITIONAL MACHINING" with options like "TIP END ANGLE/R CHANGE", "TIP END ANGLE CHANGE", "TIP END R CHANGE", "SPECIAL EAR", and "PRODUCT RECESS". Navigation buttons labeled "OK" and "CLOSE" are located on the right side of the screen. Various reference numerals (253a, 253b, 253c, 253d, 253e, 253f, 253g) are used to identify specific elements of the interface.

FIG. 30

255



TIP END ANGLE CHANGE ~ 255b

SIZE	
ITEM	VALUE
K	80
R	0.2

255c

255d

255e

255f

V WIDTH

V WIDTH

MACHINED MATERIAL

PLATE THICKNESS

6

V WIDTH

MATERIAL QUALITY

SPHC

255g

255h

MACHINING POSSIBILITY

255i

TOTAL SHOTS

1

255j

255k

SELECTION

CANCEL

GUIDANCE: RESISTING PRESSURE IS 45 TON/M AND WORKING REQUIRING PRESSURE IS 52 TON/M  
(CALCULATION AS V WIDTH = 48 MM)

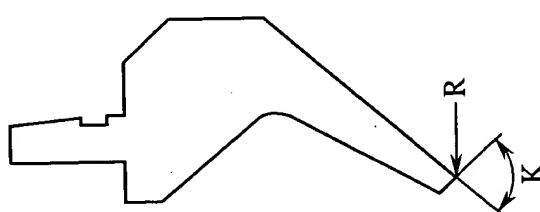
WARNING: RESISTING PRESSURE INSUFFICIENT ~ 255k

FIG.31

257

257a

MACHINING POSSIBILITY



SIZE

ITEM	VALUE
K	30
R	0.2

257c

257d

257e

257f

TIP END ANGLE CHANGE ~257b

MACHINED MATERIAL

PLATE THICKNESS

MATERIAL QUALITY

257g

TOTAL SHOTS

257h

CANCEL

ERROR : PLEASE INPUT A VALUE IN RANGE OF  $70 \leq K \leq 90$  INTO K SIZE ~257j

259

ESTIMATE PARENT NO. <span style="border: 1px solid black; padding: 2px;">A700000</span>		[DELIVERY] (LIMITED COMPANY) A WORKS/ [CONTRACT] (LIMITED COMPANY) A WORKS		259a		ITEM FOR ORDER RECEPTION	
ESTIMATE		ESTIMATE DETAILS		BLANKET DELIVERY		INPUT <span style="border: 1px solid black; padding: 2px;">10</span>	
DISCOUNT RATE		<input type="checkbox"/> EXCESS APPLICATION		<input type="checkbox"/> MAIL RESPONSE FOR PREPARED HOLE SIZE?		DELETE	
<input type="radio"/> APPLICATION		<input type="checkbox"/> SIMULTANEOUS TRIAL PUNCHING		<input checked="" type="checkbox"/> STRIP AMOUNT DISPLAY?		FIGURE REQUIRED?	
<input type="radio"/> FIX <span style="border: 1px solid black; padding: 2px;"> </span>		COMMERCIAL ARTICLE NAME		CORNER R		DEDICATED KEY	
SHAPE		A SIZE		B SIZE		ESTIMATE AMOUNT	
QUANTITY		ONE TOUCH 88° GOOSE NECK		XXX,XXX		CONFIRMATION	
Cat-No.		1 11 453021		000		COMMERCIAL ARTICLE RETRIEVAL	
Seq		2 11 45302E		000		SEPARATE DIE	
No.453 TYPE OF ANGLE, R ADDITIONAL MACHINING		DISCOUNT AMOUNT		XX,XXX		CLEAR <span style="border: 1px solid black; padding: 2px;"> </span>	
TOTAL AMOUNT		XXX,XXX		ESTIMATE AMOUNT		CALCULATION	
259d		259e		259m		259c	
COMMERCIAL ARTICLE NAME		No.453 TYPE OF ANGLE, R ADDITIONAL MACHINING (B4530KT)		SPECIAL MENTION ITEM		ESTIMATE ISSUE	
UNIT PRICE		XXX,XXX		PRICE		259n	
REFERENCE DELIVERY TIME		5		DELIVERABLE DAY		259o	
MARKING No.		10(%)		CUSTOMER REQUEST DAY		ORDER RECEPTION DECISION	
DISCOUNT RATE		10(%)		DISCOUNT AMOUNT		ORDER ACKNOWLEDGMENT	
259f		259g		259h		259k	
259b		259c		259d		259e	
259f		259g		259h		259i	
259j		259k		259l		259m	
259n		259o		259p		259q	
259r		259s		259t		259u	
259v		259w		259x		259y	
259z		259aa		259ab		259ac	
259ad		259ae		259af		259ag	
259ah		259ai		259aj		259ak	
259al		259am		259an		259ao	
259ap		259aq		259ar		259as	
259at		259au		259av		259aw	
259ax		259ay		259az		259ba	
259bb		259bc		259bd		259be	
259bf		259bg		259bh		259bi	
259bj		259bk		259bl		259bm	
259bn		259bo		259bp		259bq	
259br		259bs		259bt		259bu	
259bv		259bw		259bx		259by	
259bz		259ca		259cb		259cc	
259cd		259ce		259cf		259cg	
259ch		259ci		259cj		259ck	
259cl		259cm		259cn		259co	
259cp		259cq		259cr		259cs	
259ct		259cu		259cv		259cw	
259cx		259cy		259cz		259da	



261

FIG.33

ITEM FOR ORDER RECEPTION

ESTIMATE PARENT NO.

[DELIVERY] (LIMITED COMPANY) A WORKS/

[CONTRACT] (LIMITED COMPANY) A WORKS

261a

ESTIMATE

ESTIMATE DETAILS

☐ EXCESS APPLICATION

☐ MAIL RESPONSE FOR PREPARED HOLE SIZE?

☐ BLANKET DELIVERY

☐ SIMULTANEOUS TRIAL PUNCHING

☒ STRIP AMOUNT DISPLAY?

☐ CONFIRMATION FIGURE REQUIRED?

INPUT 10

DELETE

CANCEL

COMMERCIAL ARTICLE SELECTION

SIZE CONFIRMATION

COMMERCIAL ARTICLE RETRIEVAL

PAST SALES

SEPARATE DIE

CLEAR

CALCULATION

ESTIMATE ISSUE

ORDER RECEPTION DECISION

ORDER ACKNOWLEDGMENT

261b

TOTAL AMOUNT XXX,XXX

DISCOUNT AMOUNT XX,XXX

ESTIMATE AMOUNT XXX,XXX

COMMERCIAL ARTICLE NAME

88° PUNCH 0.2RL

PRICE XX,XXX

DELIVERABLE DAY

1998/06/30

CUSTOMER REQUEST DAY

/ /

DISCOUNT AMOUNT

XX,XXX

UNIT PRICE XX,XXX

REFERENCE DELIVERY TIME

1

MARKING No.

DISCOUNT RATE 10(%)

SPECIAL MENTION ITEM

SEQ

SPECIAL MENTION ITEM

VALUE

261d

261c

261e

261f

261g

261h

261i

FAX

34/43

## FIG.34

ESTIMATE ~ 263

JUNE 23, 1998

PAGE 1

No. A700000

LIMITED COMPANY A WORKS

REGARDING YOUR INQUIRY OF NO.XXXXXX DATED JUNE 23, WE ESTIMATE THIS CASE AS FOLLOWS, THEREFORE PLEASE LET US HAVE YOUR ORDER REGARDING THIS CASE.

263a

DELIVERY TIME AS FOLLOWS

263b

DELIVERY PLACE YOUR DESIGNATED PLACE

TEL  
FAX

263c

PAYMENT CONDITION AS USUAL

263d

DELIVERY CONDITION DELIVERY

263e

EFFECTIVE TERM OF ESTIMATE

--	--	--	--

263f

TOTAL AMOUNT      ¥ 221,580-					
ITEM	ARTICLE NAME SPEC.	QUANTITY	UNIT PRICE	AMOUNT	DELIVERY TIME
A700045-001	ONE TOUCH 88° GOOSE NECK 0.2R L No.:453021	1	XXX,XXX	XXX,XXX	
A700045-002	ONE TOUCH No.453 TYPE OF ANGLE R ADDITIONAL MACHINIG (B4530KT)	1	XXX,XXX	XXX,XXX	
		1	TOTAL AMOUNT	XXX,XXX	
			YOUR DISCOUNT	XX,XXX	
			PROPOSED PRICE	XXX,XXX	
	- BLANK BELOW -				

263g 263h

263i

700000 0902200

FIG.35

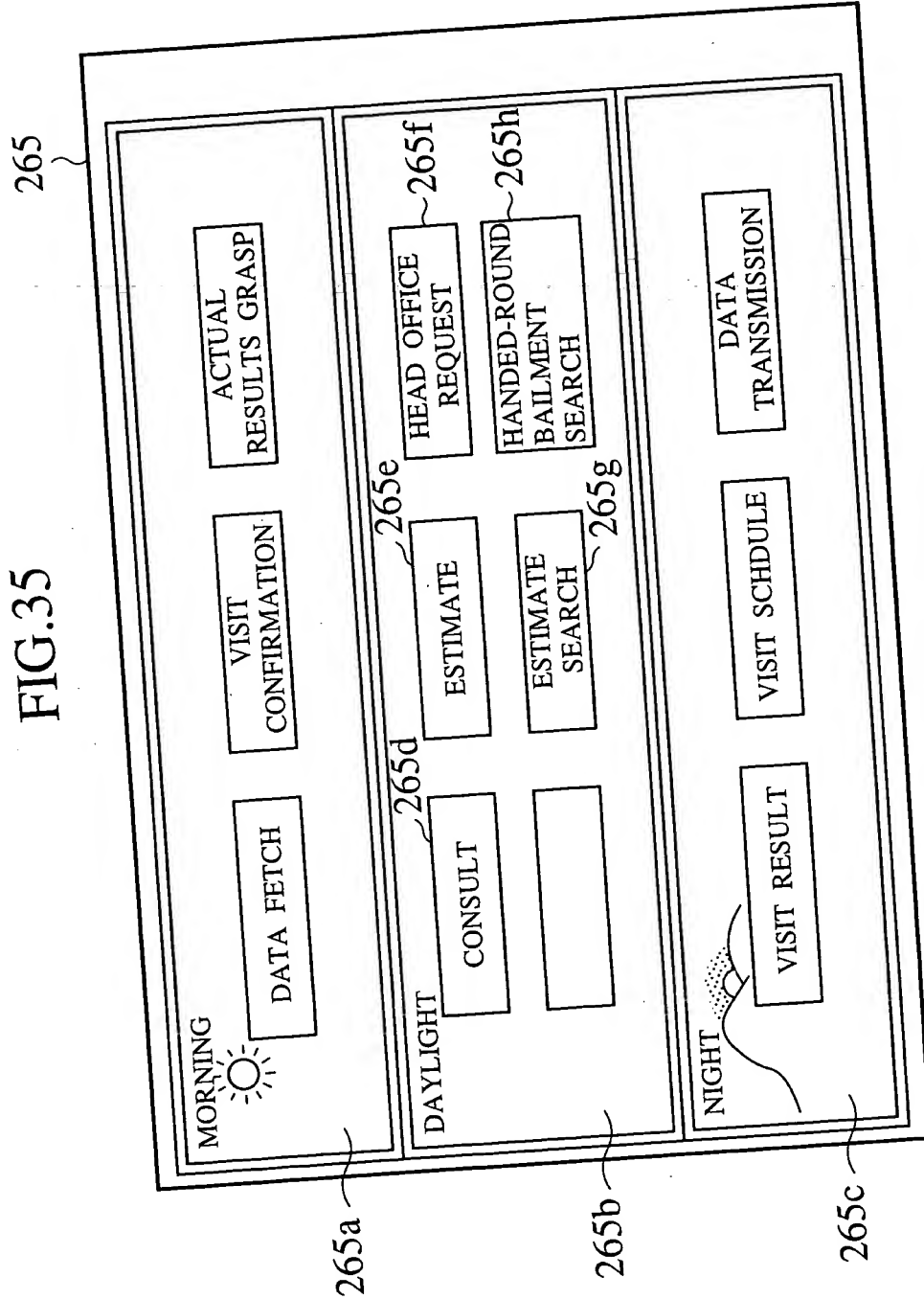


FIG.36

270

GR COMMERCIAL ARTICLE SELECTION		NON-PATTERN	
<p><b>PUNCHING BENDING SET</b></p> <ul style="list-style-type: none"> <li><input type="checkbox"/> ONE TOUCH &lt;B1&gt;</li> <li style="padding-left: 20px;">-SK=11 - &lt;C0&gt;</li> <li><input type="checkbox"/> PUNCH HOLDER &lt;C1&gt;</li> <li><input type="checkbox"/> PUNCH &lt;C2&gt;</li> <li><input type="checkbox"/> DIE &lt;C3&gt;</li> <li><input type="checkbox"/> STEP BENDING/L-SHAPE BENDING &lt;CJ&gt;</li> <li><input type="checkbox"/> STANDARD &lt;B2&gt;</li> <li style="padding-left: 20px;">-SK=10 - &lt;C7&gt;</li> <li><input type="checkbox"/> PUNCH HOLDER &lt;C8&gt;</li> <li><input type="checkbox"/> PUNCH &lt;C9&gt;</li> <li><input type="checkbox"/> DIE &lt;CA&gt;</li> <li><input type="checkbox"/> MEASURING INSTRUMENT &lt;CG&gt;</li> <li><input type="checkbox"/> TOOL BOX &lt;CH&gt;</li> <li><input type="checkbox"/> STEP BENDING/L-SHAPE BENDING &lt;C1&gt;</li> </ul> <p style="background-color: black; color: white; text-align: center; margin-top: 5px;"><b>SELECTION FROM WORKPIECE &lt;B3&gt;</b></p>	<div style="float: right; width: 100px; text-align: center;">270a</div>		
<p><b>SHAPE FIGURE I</b></p> <p style="font-size: 1.2em; font-weight: bold;">270c</p> <p style="text-align: center;">SELECTION OF WORKPIECE SHAPE</p>	<p style="text-align: center;">ADAPTIVE FIGURE</p> <div style="border: 1px solid black; height: 150px; width: 100%;"></div> <div style="display: flex; justify-content: space-between; align-items: center; margin-top: 10px;"> <span style="border: 1px solid black; padding: 2px 5px;">SELECTION</span> <span style="border: 1px solid black; padding: 2px 5px;">CLOSE</span> </div>		



FIG. 38

FIG. 38

274

NON-PATTERN

PUNCHING BENDING SET SHAPE FIGURE

ONE TOUCH (R1)

RETURN BEND CHECK

STANDARD ONE TOUCH

WORKPIECE SIZE

INPUT

PLATE THICKNESS 1.2 mm

W SIZE L SIZE

(WIDTH) = (DEPTH) =

25 mm 50 mm mm mm

mm mm mm mm

ADDITION AND DRAWING

INPUT PATTERN CANCEL

HOLDING TYPE O Z I O Z II

DIE PLEASE SELECT

No.004

No.004 (FOR BR RECESS No.1)

No.004 (FOR BR RECESS No.2)

No.004 (FOR BR RECESS No.3)

No.117

CLEAR FIGURE

RETURN TO MENU

DETAIL

ADDITIONAL MACHINING & RESISTING PRESSURE CALCULATION

272d

276

FIG.39

GR

ES

Se

CO

AR

UN

RE

DE

MA

PUNCHING

BENDING

SET

ONE TOUCH (R1)

SHAPE FIGURE

DIE SELECTION

NON-PATTERN

☒ STANDARD

☐ ONE TOUCH

[WORKPIECE SIZE]

...INPUT

PLATE THICKNESS

1.2 mm

W SIZE L SIZE

(WIDTH)=(DEPTH)=

25 mm

50 mm

mm

mm

mm

mm

[INPUT PATTERN]

W=25.00 L=50.00 F=00

CANCEL

[HOLDER TYPE]

☐ Z I

☐ Z II

[DIE] ...PLEASE SELECT

No.453

ALP (FOR BR RECESS No.4)

No.045

No.047

No.516

CLEAR FIGURE

×1.0

276a

272a

276b

[No.453]

272d

No.453

ALP (FOR BR RECESS No.4)

No.045

No.047

No.516

RETURN TO MENU

DETAIL

ADDITIONAL MACHINING & RESISTING PRESSURE CALCULATION

278

FIG.40

**PUNCHING BENDING SET**

**ADDITIONAL MACHINING JUDGEMENT**

[WORKPIECE MATERIAL QUALITY SELECTION]

TENSILE STRENGTH=28 SPCC 1.2t

[DIE SELECTION]

INWARDLY BENDING RADIUS  $\approx V/6$

☐ 1V DIE ☒ 2V DIE

V WIDTH 8

V ANGLE 88°

**278c**

124(8×12)

30310(8×12)

[CALCULATION RESULT]

BENDING TONS = BOTTOMING

PUNCH WARRANTY	50 ton/m
RESISTING PRESSURE	80 ton/m
DIE WARRANTY	
RESISTING PRESSURE	
BENDING TONS	12.0 ton/m
MINIMUM FLANGE LENGTH	5.5mm
PUNCH RESISTING PRESSURE	RESISTING PRESSURE OK
DIE RESISTING PRESSURE	RESISTING PRESSURE OK
DIE WARPING	0.02mm

**RETURN**

**REFER TO AMOUNT**

**NON-PATTERN**

**278**

**276a**

**278b**

**272a**

**278a**

**278**

X=-19.464

Y=49.598

[No.453]

×1.0

**DETAIL**

**ADDITIONAL MACHINING & RESISTING PRESSURE CALCULATION**



280

FIG.41

GR		PUNCHING		BENDING		SET		NON-PATTERN	
ES		ONE TOUCH (P1)		SHAPE FIGURE					
		REFER TO CATNO DECISION & PRICE							
		BLADE EDGE ANGLE		O 90° O OTHERS					
		LENGTH		O 835mm(L) O 415mm(S) O DIVISION					
		TIP END R		O 0.2R O 0.6R O 0.8R O 1.5R O 3.0R					
		DIE & CATNO		GOOSE NECK PUNCH 6mm					
				453021					
		PRICE		280a		280b			
		DIE FEE		XXX,XXX		XXX,XXX			
		ADDITIONAL MACHINING FEE		XX,XXX		XX,XXX			
		TOTAL		XXX,XXX		XXX,XXX			
		DECISION							
		RETURN							
		PRINT							
		DETAIL							
		X1.0							
		X=-19.464							
		Y=49.598							
		[No.453]							
		ADDITIONAL MACHINING & RESISTING PRESSURE CALCULATION							

282

FIG.42

GR

ES

Se

CO

AR

UN

RE

DE

MA

PUNCHING

BENDING

SET

UNSUITABLE DIE SELECTION

NON-PATTERN

ONE TOUCH <R1>

SHAPE FIGURE

☐ STANDARD

☒ ONE TOUCH

[WORKPIECE SIZE]

◆

...INPUT

PLATE THICKNESS

1.2 mm

W SIZE

L SIZE

(WIDTH)=(DEPTH)=

25 mm

50 mm

mm

mm

mm

mm

[INPUT PATTERN]

CANCEL

[HOLDER TYPE]

☐ Z I

☒ Z II

[DIE] ...PLEASE SELECT

No.004

No.004 (FOR BR RECESS No.1)

No.004 (FOR BR RECESS No.2)

ALP (FOR BR RECESS No.3)

No.117

CLEAR FIGURE

274a

67

282a

282b

Y=49.598

X=-19.464

Y=49.598

X=-19.464

Y=49.598

X=-19.464

67

282b

Y=49.598

X=-19.464

Y=49.598

X=-19.464

×1.0

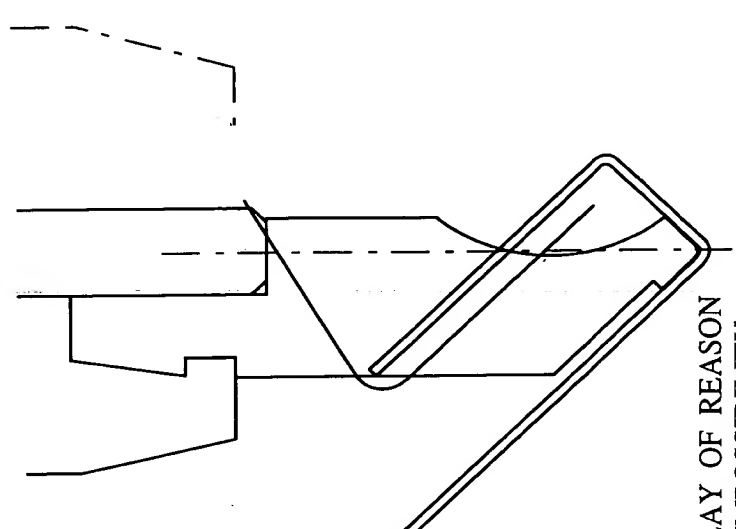
ADDITIONAL MACHINING & RESISTING PRESSURE CALCULATION

RETURN TO MENU

DETAIL

284

FIG.43

GR	ES	Se	CO	AR	UN	RE	DE	MA																		
<div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; padding-bottom: 5px;"> <span>PUNCHING</span> <span>BENDING</span> <span>SET</span> </div> <div style="display: flex; justify-content: space-between; border-bottom: 1px solid black; padding-bottom: 5px;"> <span>ADDITIONAL MACHINING JUDGEMENT</span> <span>NON-PATTERN</span> </div>																										
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><b>[WORKPIECE MATERIAL QUALITY SELECTION]</b></p> <p>SPCC <span style="border: 1px solid black; padding: 2px;">1.2t</span></p> <p><b>[DIE SELECTION]</b></p> <p>INWARDLY BENDING RADIUS <math>\cong V/6</math></p> <p>○ 1V DIE    ⊙ 2V DIE</p> <p>V WIDTH <span style="border: 1px solid black; padding: 2px;">8</span></p> <p>V ANGLE <span style="border: 1px solid black; padding: 2px;">88°</span></p> <p><span style="border: 1px solid black; padding: 2px;">124(8×12)</span></p> <p><span style="border: 1px solid black; padding: 2px;">30310(8×12)</span></p> </div> <div style="width: 50%;"> <p><b>[CALCULATION RESULT]</b></p> <p>BENDING TONS = BOTTOMING</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">PUNCH WARRANTY</td> <td style="width: 50%;">ton/m</td> </tr> <tr> <td>RESISTING PRESSURE</td> <td></td> </tr> <tr> <td>DIE WARRANTY</td> <td></td> </tr> <tr> <td>RESISTING PRESSURE</td> <td></td> </tr> <tr> <td>BENDING TONS</td> <td></td> </tr> <tr> <td>MINIMUM FLANGE LENGTH</td> <td></td> </tr> <tr> <td>PUNCH RESISTING PRESSURE</td> <td></td> </tr> <tr> <td>DIE RESISTING PRESSURE</td> <td></td> </tr> <tr> <td>DIE WARPING</td> <td></td> </tr> </table> </div> </div>									PUNCH WARRANTY	ton/m	RESISTING PRESSURE		DIE WARRANTY		RESISTING PRESSURE		BENDING TONS		MINIMUM FLANGE LENGTH		PUNCH RESISTING PRESSURE		DIE RESISTING PRESSURE		DIE WARPING	
PUNCH WARRANTY	ton/m																									
RESISTING PRESSURE																										
DIE WARRANTY																										
RESISTING PRESSURE																										
BENDING TONS																										
MINIMUM FLANGE LENGTH																										
PUNCH RESISTING PRESSURE																										
DIE RESISTING PRESSURE																										
DIE WARPING																										
<div style="display: flex; justify-content: space-between; align-items: flex-end; padding-top: 10px;"> <div style="width: 45%;"> <p><b>[REASON FOR IMPOSSIBILITY]</b></p>  <p style="text-align: center;">284a</p> </div> <div style="width: 50%;"> <p><b>[No.004]</b></p> <p>X=-19.464    Y=49.598</p> <p><span style="border: 1px solid black; padding: 2px;">×1.0</span></p> </div> </div>																										
<div style="display: flex; justify-content: space-between; border-top: 1px solid black; padding-top: 5px;"> <span>DETAIL</span> <span>ADDITIONAL MACHINING &amp; RESISTING PRESSURE CALCULATION</span> </div>																										
<p>NOTE: SHORTAGE OF THICKNESS OF UPPER PORTION OF PUNCH</p> <p style="text-align: center;">RETURN</p>																										